

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001431**Date Inspected:** 21-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1000**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huwei Quing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Caltrans Quality Assurance Inspector Gabriel Quintana (QA Inspector) arrived at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to observe fabrication and Quality Control Inspectors (QC Inspectors) perform their duties and responsibilities as specified in the contract documents, approved plans, fabrications documents and Special Provisions for this project. While on site the QA Inspector observed the following.

Bay 7- QA Inspector observed that the QA/UT Verification testing of indication previously found by QA Inspection had not been addressed by QC Inspectors on FB17-02, FB26-02, FB22-01 and FB22-02. QA Inspector observed that the Floor Beams have been turned over and the lay out for tack welding the rib stiffeners is in progress. QA Inspector informed QC Inspector Huwei Qing and Shen Xue Jun that further work will be at risk if the stiffeners are welded to the Floor Beams without QA verification that the welds are in compliance with AWS D1.5- 2002 Table 6.3 and the contract documents. QC Inspector Shen Xue Jun informed QA Inspector that welding of the rib stiffeners will not progress until further testing is completed to determine the cause of the indications found by Ultrasonic Testing (UT).

**Summary of Conversations:**

General communications took place between the QA and QC Inspector.

**Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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## WELDING INSPECTION REPORT

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| <b>Inspected By:</b> | Quintana, Gabriel | Quality Assurance Inspector |
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| <b>Reviewed By:</b> | Cochran, Jim | QA Reviewer |
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